

29

Date: Tuesday, 6/19/2007 2:13:03 PM
 Year: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (19"X16")
Job Number	: 32977		
Estimate Number	: 12664		
P.O. Number	: <i>N/A</i>	Part Number	: D206559011
This Issue	: 6/19/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2435 REV E1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NA</i> Type : MACHINED PARTS	Drawing Revision	: E1
Previous Run	: 30800	Material	: <i>NA</i>
Written By	: <i>[Signature]</i>	Due Date	: 7/20/2007 Qty: 5 Um: Each
Checked & Approved By	: <i>[Signature]</i> 07.06.20		
Comment	: Est Rev: C 04.02.17 Blank size changed KJ/JLM Est Rev: D 07-01-02 Was K10007 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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KE 07.06.21

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPPD206-559-011 CHG005

07/10/27

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 4.5491 sf(s)/Unit Total : 22.7456 sf(s)

blank: 19.500" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-3

Material: Black UHMW 1"

(MUHMWB10)

Batch: *B105862*
ml 07/10/27

10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2435 Identify as D2435

3-Deburr

ml 07/10/27

10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07/10/27

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/19/2007 2:13:03 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 07/10/29

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 1.6660 f(s)/Unit Total : 8.3300 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B050 Rubber Cushion B30872

AS 07/10/30

8.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block B32857

2 D2435(ref only) Bearpaw 32977

AS 07/10/30

9.0

D2438

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2438 Clamp B33937

AS 07/10/30

10.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer B35356

AS 07/10/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/19/2007 2:13:03 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 32977

Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

HTT
S
⑤

11.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A

Bolt

M104746

AS 07/10/30

HTT
S
⑤

12.0

AN417A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

Batch: M103691

AS 07/10/30

HTT
S
⑤

13.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

~~M106043~~
M105426

AS 07/10/30

HTT
S
⑤

14.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M105054

AS 07/10/30

HTT
S
⑤

15.0

QS200M44S

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 QS200M44S

Clamp

B105516

1 Paperwork package

AS 07/10/30

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 07/10/31 (57465)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 21/1/00
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/19/2007 2:13:03 PM
User: -Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 32977

Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-011

Location: A

07/10/31 AS

AI

18.0

QC21

FINAL INSPECTION/W/O RELEASE



10

Comment: FINAL INSPECTION/W/O RELEASE

D206559011

Job Completion



U 57-10-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
98.06.17 KE

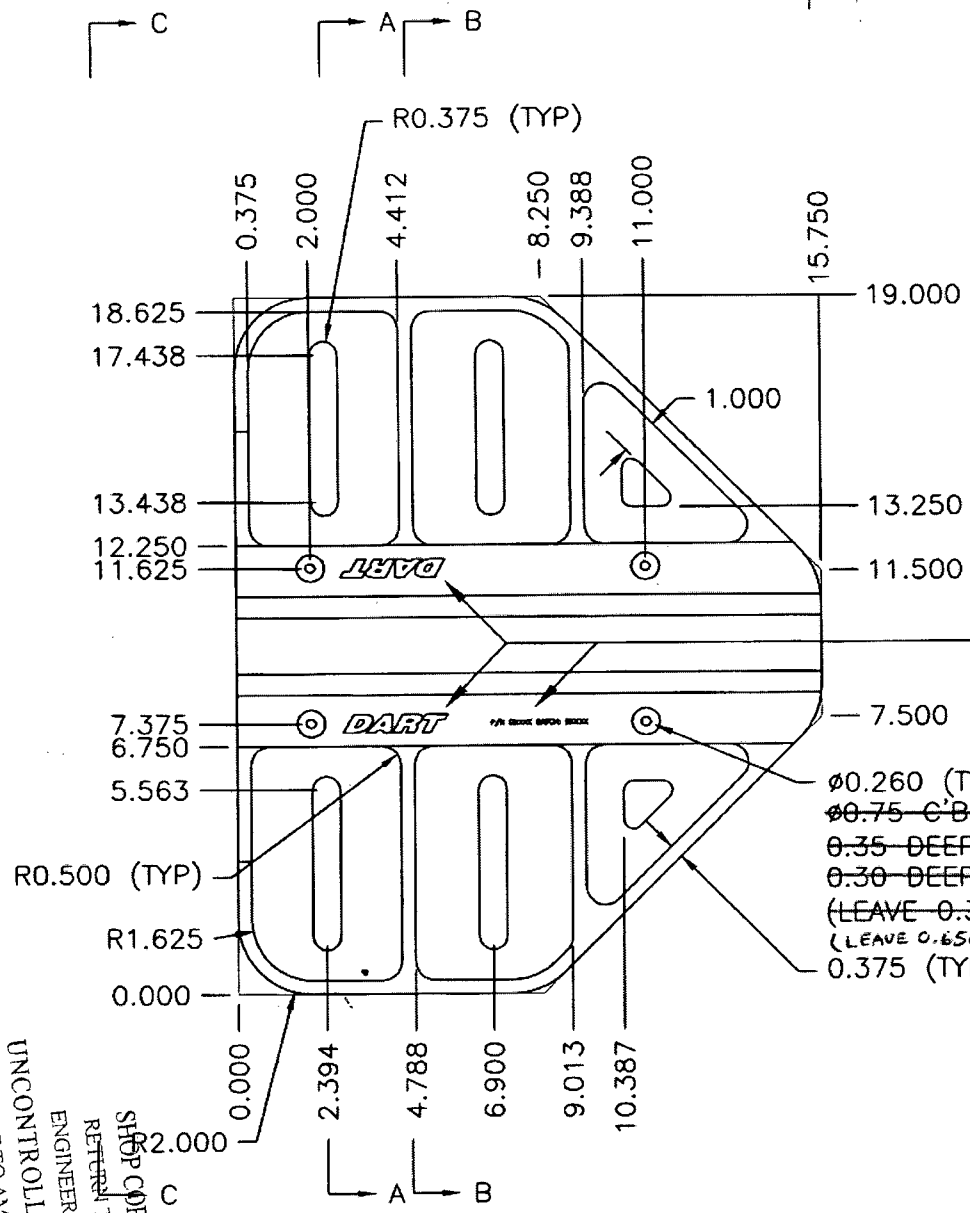
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
CHECKED KE	APPROVED KE	DRAWING NO. D2435	SHEET 1 OF 2
DATE 98.05.19	TITLE BEARPAW	SCALE 1:5	
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

EFFECTIVE DEOS

9143	
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ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

E1 02.12.17 $\phi 0.93$ WAS $\phi 0.75$ ~~FEH~~



$\phi 0.260$ (TYP) $\phi 0.93$ C'BORE
 ~~$\phi 0.75$ C'BORE~~ 0.30 DEEP FROM BOTTOM
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)
0.375 (TYP)

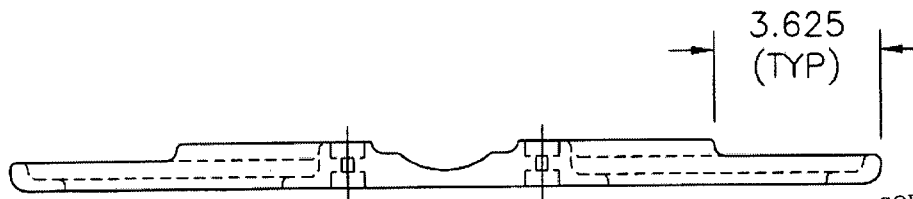
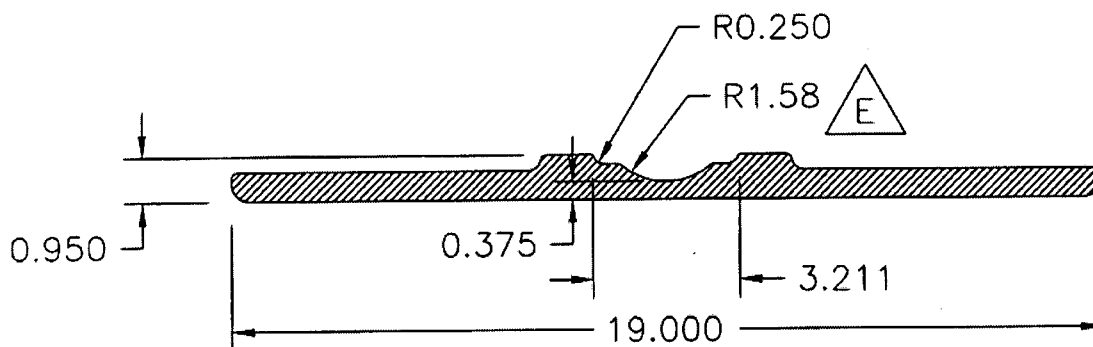
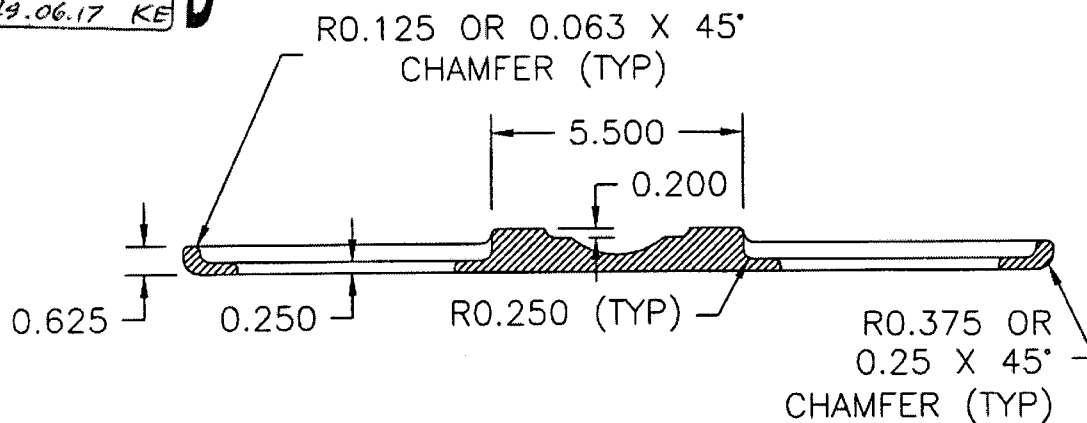
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
WITHOUT NOTICE



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DIB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
99.06.17 KE



SECTION C-C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32977

DART AEROSPACE LTD		Work Order: 32977
Description: Bearpaw		Part Number: D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.053 x 45°	—			
B	5.500	+/-0.030	5.499	—			
C	0.200	+/-0.030	0.205	—			
D	R0.250	+/-0.030	R0.250	—			
E	0.250	+/-0.010	0.245	—			
F	0.625	+/-0.030	0.617	—			
G	0.25 x 45°	+/-0.030	0.236 x 45°	—			
H	0.375	+/-0.010	0.377	—			
I	19.000	+/-0.030	19.000	—			
J	0.950	+0.030/-0.010	0.964	—			
K	Ø0.260	+0.005/-0.000	Ø0.260	—			
L	Ø0.930	+/-0.030	Ø0.928	—			
M	0.30	+0.030/-0.000	0.313	—			
N	0.375	+/-0.030	0.377	—			
O	7.375	+/-0.030	7.375	—			
P	4.250	+/-0.010	4.250	—			
Q	2.000	+/-0.030	2.000	—			
R	9.000	+/-0.010	9.000	—			
S	15.750	+/-0.030	15.750	—			

Measured by: <i>gml</i>	Audited by: <i>BF</i>	Prototype Approval:	N/A
Date: 07/10/27	Date: 07/10/27	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	

Customer : CC-DAR01 Dart Aerospace Ltd.
Job Number : 36674
Estimate Number : 10804
P.O. Number : *N/A*
This Issue : 09/01/2008 S.O. No. : *N/A*
Prsht Rev. : *NC*
First Issue : *N/A* Type : MACHINED PARTS
Previous Run : 00015
Written By :
Checked & Approved By :
Comment :

Drawing Name : D206-559

Part Number : Z_CUSTOM
Drawing Number : ECN1101
Project Number : *N/A*
Drawing Revision : *N/A*
Material : *N/A*
Due Date : 16/01/2008

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REMOVE FROM STOCK:

D206-559-011

B34284 (10x) B30377(x2) B30800(x1) B32977(x5)

D206-559-013

B32768 9x B30340 (2x)

D206-559-021

B28342 (x4)

D206-559-023

B25291(x3) B34856(x5)

D206-559-025

B28731 (x4)

ADD NEW PAPERWORK JCAB STC: STC-90-TYO
PER ECN 1101

RETURN TO STK

8/1/10 SD (45x) AS

2.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

208/01/11

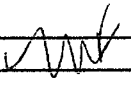
Job Completion



W 28-01-11

Date: Thursday, 01/05/2008 1:56:32 PM
 User: Melanie Fauteux

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D206559011
Job Number : 38954	
Estimate Number : 10804	
P.O. Number :	Part Number : ECN30
This Issue : 01/05/2008 S.O. No. :	Drawing Number : ECN1022
Prsht Rev. : NC	Project Number :
First Issue : / / Type : MACHINED PARTS	Drawing Revision :
Previous Run : 38917	Material :
Written By :	Due Date : 01/05/2008 Qty: 1 Um: Each
Checked & Approved By : 	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

UPDATE PAPERWORK:

D206559011

B

32977 (X)
 34288 8x
 37535 6x

ADD IIN+ ICA + MDL TO KITS

PER ECN1022

CHANGE LABELS TO NEW CHANGE NUMBER

CHG006

RETURN TO STOCK

8/5/5 SLP 15x

2.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/05/06

Job Completion



MUF 08/05/05

1000

1000

1000

1000

1000

1000

1000

1000

1000

1000

1000

1000

1000

1000